

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027694**Date Inspected:** 30-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

**OBG Deck Access Holes**

QAI observed the excavation of Ultrasonic Testing rejects of the circumference weld on Deck Access Hole 12W-PP109.5-W2. Excavation dimensions are as follows:

- Y=125mm, L=15mm, D=13mm, W=20mm
- Y=1185mm, L=10mm, D=15mm, W=20mm

At the conclusion of excavations QC Technician William Sherwood performed Magnetic Particle Testing (MPT), utilizing the Parker Contour Probe #19881 with a calibration date of 3/22/12, on the excavations of the Ultrasonic Testing rejects of Deck Access Hole 12W-PP109.5-W2. Red powder was used to provide contrast between the base metal and weld metal.

QAI observed the repair welding of the above-mentioned Ultrasonic Testing rejects on Deck Access Hole 12W-PP109.5-W2. Welding was being performed by Eric Sparks (ID#3040) using the Shield Metal Arc Welding (SMAW) Process at 127 amps using an E7018H4R consumable electrode.

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QC William Sherwood was observed by this QAI performing in-process weld inspection and QC verification using the applicable Welding Procedure Specification. This QAI observed and verified the welding and QC inspection at random intervals.

QAI observed the excavation of Ultrasonic Testing reject of the circumference weld on Deck Access Hole 12W-PP61.5-W2. Excavation dimensions are as follows:

- Y=560mm, L=40mm, D=12mm

No welding was performed on the above-mentioned Ultrasonic Testing reject due to the repair being an R3 and the contractor is awaiting engineer approval.

OBG West Drop-in Splice W13/W14.

This QAI observed the welding of the back gouged backside of weld joint 13W-14W-A1. The welding was being performed by Michael Jiminez in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 126 amps using an E7018H4R consumable electrode.

QC William Sherwood was observed by this QAI performing in-process weld inspection and QC verification using the applicable Welding Procedure Specification. This QAI observed and verified the welding and QC inspection at random intervals.



## Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Daggett,Matt

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer